



Dart Aerospace Ltd.
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Canada

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D4776-3

Job Sheet 194368



Part No: D4776-3

Job Qty: 10 pcs

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4776 REV.E IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		5/31/19	0.00	0.18	Bandsaw - 1		mm L 19/05/14
110	HAAS 4 Axis - B4B	10 pcs		5/31/19	0.26	8.70	HAAS - 1 - B4B		mm L 19/05/14
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	10 pcs		5/31/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		mm L 19/05/14
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S181236



Part: D4776-3

Job No: 194368

Serial No/Batch: S181236

Revision: E

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/14/19

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130 QC 8	10 pcs	5/31/19	0.00 0.00	QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	mk19/05/16
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	5/31/19	0.00 0.26	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	MAY 22 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 -	

				B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150	QC 7	10 pcs	5/31/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
160	Powdercoat - 1 White Gl(A)- B4B	10 pcs	5/31/19	0.00 0.12	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
170	QC 3	10 pcs	5/31/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9

3/19-5-22

Bd 19-5-22

160 Powdercoat - 1 White Gl(A)- B4B *M151749*
START: 3:00 O.T. 3:00 FINISH: 3:50

MAY 23 2019

40

9-89

180 Packaging 3-1 - Stock - B4B	10 pcs	5/31/19	0.00 0.00	QC 3 - 40	
				QC 3 - 19	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	10 pcs	5/31/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

MAY 27 2019

Part Op 100 - Cut Blank at 4.625"

Descriptions: 110 - 1-Machine per folio FB168 DWG REV: E FOLIO REV: AA 2- deburr and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	3.8600 ft (.386 ea)	100-Bandsaw - 1	SICCS 74 = 12'

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.500X2.500	4	64	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.430inches $\pm$ 0.030	4.460 4.400		4.423
2	Skidtube Clevis	2.300inches $\pm$ 0.030	2.330 2.270		2.299
3	Skidtube Clevis	1.778inches $\pm$ 0.010	1.788 1.768		1.779
4	Skidtube Clevis	0.880Inches $\pm$ 0.030	0.910 0.850		0.876
5	Skidtube Clevis	0.510Inches $\pm$ 0.010 + 0.010 - 0.000	0.520 0.510		.510
6	Skidtube Clevis	1.063Inches $\pm$ 0.010	1.073 1.053		1.063
7	Skidtube Clevis	1.380Inches $\pm$ 0.030	1.410 1.350		1.380
8	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160		0.190
9	Skidtube Clevis	0.100inches $\pm$ 0.010	0.110 0.090		.097
10	Skidtube Clevis	0.484Inches $\pm$ 0.006 - 0.001	0.490 0.483	Diameter	.487
11	Skidtube Clevis	0.500Inches $\pm$ 0.030	0.530 0.470		.500
12	Skidtube Clevis	0.640inches $\pm$ 0.030	0.670 0.610		.638
13	Skidtube Clevis	3.150Inches $\pm$ 0.010	3.160 3.140		3.150
14	Skidtube Clevis	1.080inches $\pm$ 0.010	1.090 1.070		1.081
15	Skidtube Clevis	0.688Inches $\pm$ 0.010	0.698 0.678		0.687
16	Skidtube Clevis	0.397Inches $\pm$ 0.006 - 0.001	0.403 0.396	Diameter	.398
17	Skidtube Clevis	1.863inches $\pm$ 0.010	1.873 1.853		1.858
18	Skidtube Clevis	0.190Inches $\pm$ 0.030	0.220 0.160	Radius	.190
19	Skidtube Clevis	0.130Inches $\pm$ 0.030	0.160 0.100	Radius	.130
20	Skidtube Clevis	0.440Inches $\pm$ 0.030	0.470 0.410	Radius	.440
21	Skidtube Clevis	0.125Inches $\pm$ 0.010	0.135 0.115		.124
24	Skidtube Clevis	0.250Inches $\pm$ 0.030	0.280 0.220	Radius	.250
25	Skidtube Clevis	1.050inches $\pm$ 0.030	1.080 1.020	Product	1.047
26	Skidtube Clevis	1.430 $\pm$ 0.030			1.426
27	Skidtube Clevis	1.130inches $\pm$ 0.030	1.160 1.100	Product	1.125
28	Skidtube Clevis	0.060 $\pm$ 0.030		Product	.600
29	Skidtube Clevis	0.810inches $\pm$ 0.030	0.840 0.780	Product	.810
30	Skidtube Clevis	0.060 $\pm$ 0.030		Product	.060
31	Skidtube Clevis	0.183inches $\pm$ 0.010	0.193 0.173	Product	.180

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					